DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-018415
Date Inspected: 30-Nov-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 1000
OSM Departure Time: 1830
Location: Jobsite

CWI Name: See below

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

1). OBG Field Splice 7W/8W Weld ID: C1 & C2, Face A – (FCAW-G)
2). OBG Field Splice 6E/7E Weld ID: F1, Face A – (QAI Verification)
3). OBG Field Splice of Access Penetration Insert Welds (QA verification)

1). OBG Field Splice 7W/8W Weld ID: C1 & C2, Face A – (FCAW-G)

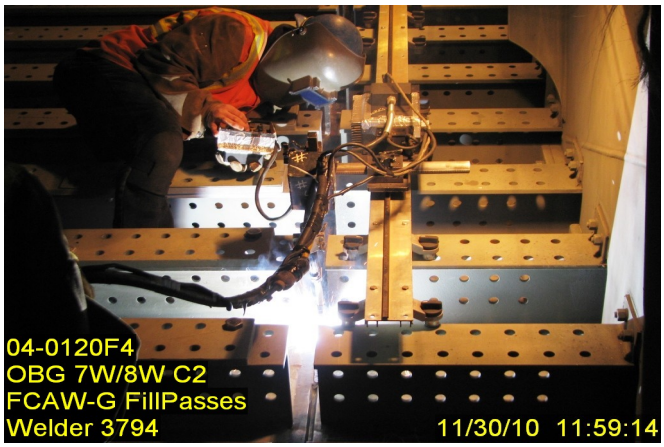
The QAI periodically observed the in process field welding of OBG Field Splice 7W/8W Weld ID: C1 & C2, Face A per the Flux Cored Arc Welding (FCAW-G) process in the 3G (vertical) position by Approved AB/F welder Song Tao Huang (ID 3794) assisted by Approved AB/F welder Jin Quan Huang (ID 9340). See photo below. QC Inspector Tony Sherwood was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1. 5-3042B-1. The QAI observed that the welding parameters obtained by Mr. Sherwood appeared to be in general compliance with the approved WPS and were as follows: Welding Amperes = 250, Welding Volt = 23.3, Travel Speed = 270 mm/min and the Heat Input was calculated by the QAI as 1.29 kilojoules/mm. Welding of fill and cover passes was in process for the remainder of this shift and the work at this location appeared to be in general compliance with contract documents..

2). OBG Field Splice 6E/7E Weld ID: F1, Face A – (QAI Verification)

The QAI performed verification Ultrasonic Testing (UT) of 10% of the length of OBG Field Splice 6E/7E Weld

ID F1. The OBG Field Splice was verified from Y = 600mm to Y = 800mm by the QAI and appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.

3). OBG Field Splice of Access Penetration Insert Weld (QA verification)
2E PP17.5 E2 SE
The QAI performed verification Ultrasonic Testing (UT) of 10% of the length of the OBG Field Splice of Access Penetration Insert Weld at 2E PP17.5 E2 SE from Y = 100mm to Y = 600mm. The OBG Field Splice verified by the QAI at this location appeared to be in general compliance with contract documents. See Ultrasonic Testing Report Form TL-6027 generated by the QAI on this date.



Summary of Conversations:
Conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities and locations of welds released to the QAI for verification testing.

Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385 5910, who represents the Office of Structural Materials for your project.

Inspected By:	Madison,Bert	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer